

Date: Wednesday, 6/28/2006 4:17:26 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|-----------------------------------------------|------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BUSHING |
| Job Number | : 27738 | | |
| Estimate Number | : 10308 | | |
| P.O. Number | : N/A | Part Number | : D26173 |
| This Issue | : 6/28/2006 | S.O. No. | : N/A |
| Prsht Rev. | : NC | Drawing Number | : D2617 REV D2 |
| First Issue | : N/A | Project Number | : N/A |
| Previous Run | : 24400 | Drawing Revision | : D2 |
| | | Material | : N/A |
| Written By | : <u>See comment below</u> | Due Date | : 7/22/2006 |
| Checked & Approved By | : <u>06/06/09</u> | Qty: | 20 |
| Comment | : Est G 04.07.14 Reformat; added step 5KJ/JLM | Um: | Each |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------------|--------------------------|
| 1.0 | M6061T6T0375W058 | 6061-T6 Tube .375 x.058W |
|-----|------------------|--------------------------|



Comment: Qty.: 0.0765 f(s)/Unit Total: 1.5309 f(s)

6061-T6 Round Bar 1.5"

Material : 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.375" tubing x 0.058" wall

(M6061T6T0.375W.058) Batch: M19051

06/07/19

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE

Turn as per Folio FA437 and Dwg D2617

N/A Machined Manually
06/07/19 22

| | | |
|-----|-----|----------------------------------------|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|----------------------------------------|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/07/19 22

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

06/07/19 x 22

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges 0.005 to 0.010

06/07/19 22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 9 Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:17:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 27738

Part Number: D26173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Acid etch and Alodine as per QSI 005 4.1

SAD 06/07/20 (22)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 07.21 (22)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5153

AB 06/07/21 (22)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/24 (22)

Job Completion



06.07.24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

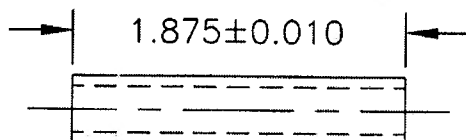
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

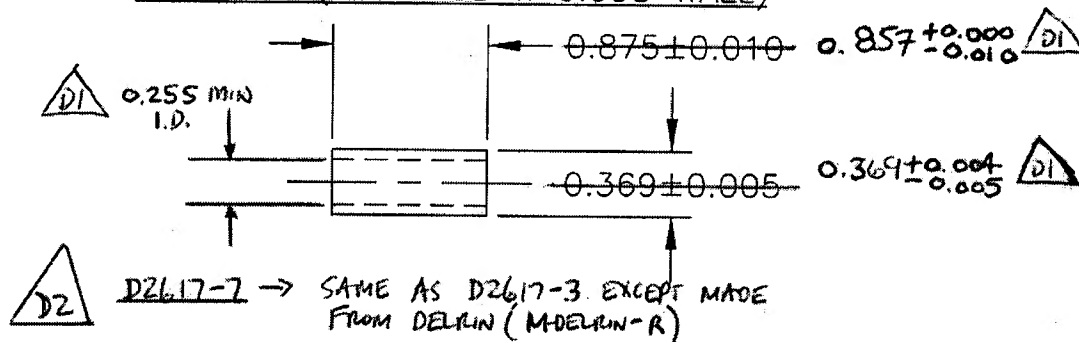


| | | | | | |
|----------|--------------|-----------------------------|----|--------------------|--------------------------------------------|
| DESIGN | BW | DRAWN BY | CP | DART AEROSPACE LTD | |
| | | HAWKESBURY, ONTARIO, CANADA | | | |
| CHECKED | # | APPROVED | # | DRAWING NO. | REV. D |
| | | | | D2617 | SHEET 1 OF 1 |
| DATE | | TITLE | | SCALE | |
| 01.07.04 | | BUSHING | | 1:1 | |
| DZ | 04.09.10 #CP | ADD D2617-7 | | A | 96.10.08 NEW ISSUE |
| | | | | B | 97.05.08 .875 WAS 1.125 |
| | | | | C | 97.06.04 0.369 DIA WAS 0.375 |
| | | | | D | 01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE |
| | | | | DI | CP-# 04.07.12 CORRECT TOLERANCE (NCR 779) |

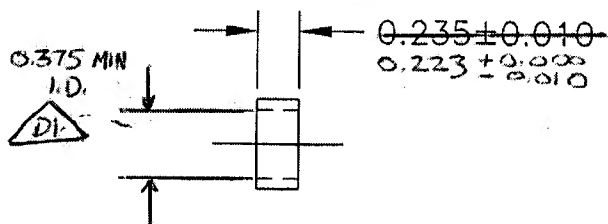
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 #

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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